

Work Order ID 76994

November-24-11 2:44:56 PM

\*76994\*

Page 1

Item ID: D3404-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: GHW Lug

Stop

\*NS2\*

Start Date: 24/11/2011 Start Qty: 40.00

\*40\*

Cust Item ID:

Required Date: 08/12/2011 Req'd Qty: 40.00

\*40\*

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/11/24

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr								
D3404	Rev C								

100 0.00

\*100\* BAND SAW

Bandsaw

Memo

0.00

ml 11/12/07

40

Jeaspa Bandsaw

Cut blank: 2.750" long

110 0.00

\*110\* HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

ml 11/12/11

HAAS CNC vertical machine #1

1-Machine as per Folio FA555 and Dwg D3404Dwg Rev: C Folio Rev:  
AA 2-Deburr

120 0.00

\*120\* QC

Memo

0.00

ml 11/12/11

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

20 11.12.13

40

4

\*130\*

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location

WA

0.00

\*140\*

Packaging

Memo

30

0.00

*Calif/14-40*

150

QC21- Final Inspection - Work Order Release

0.00

\*150\*

QC

Memo

0.00

Quality Control

*11/12/14*

*MF  
11-12-14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

November-24-11 2:44:59 PM

Page 1

Work Order ID: 76994

\*76994\*  
\*D3404-1\*

Parent Item: D3404-1

Parent Item Name: GHW Lug

Start Date: 24/11/2011

Required Date: 08/12/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A05.09.01New issueKJ/JLM  
IPP rev B 09.01.28 new geometry rev.C EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.750X2.500  *M304B0 750X2 500* 304 BAR .750 X 2.50		Purchased	No			100	f	10.8000	0.2291	9.646316			**

Location	Loc Qty	Loc Code
MAT050	10.8	
115869	10.8	

10.8 on 11/12/07

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DART AEROSPACE LTD	Work Order:	76994
Description: GHW Lug	Part Number:	D3404-1
Inspection Dwg: D3404	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## First Article    Prototype

Measured by:	<u>cmf</u>	Audited by:	<u>RQ</u>	Prototype Approval:	N/A
Date:	<u>11/21/11</u>	Date:	<u>11.12.13</u>	Date:	<u>N/A</u>

Rev	Date	Change	Revised by	Approved
A	06.04.12	New Issue	KJ/JLM	
B	09.05.04	Dimensions updated per Dwg Rev. C	KJ/DD	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

8 . . . . . 7 . . . . . 6 . . . . . 5 . . . . . 4 . . . . . 3 . . . . . 2 . . . . . 1 . . . . .

D

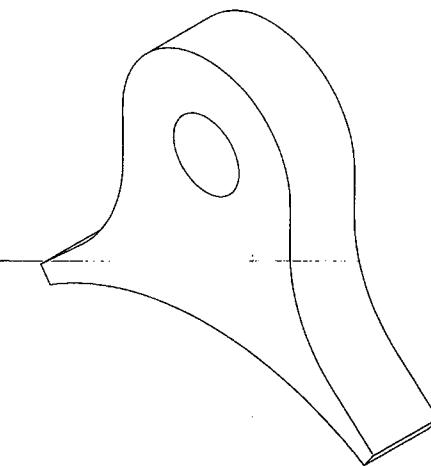
D

6

2

8

8



**D3404-1 GHW LUG**

### SHOP COPY

RETURN TO

## ENGINEERING

UNCONTROLLED COPY

**SUBJECT TO AMENDMENT**

## WITHOUT NOTICE

WORK ORDER  
NO. 76954 M.C.T

11/11/24

COPY		
ENT		
M.C.J		
111/24		
<b>RELEASED</b> <div style="border: 1px solid black; padding: 2px; display: inline-block;">08/12/18 NW</div>		
WORKS WITH CURRENT TO "B" SIZE BORDER. 1.14 DIM WAS 1.20.		AJS      08.12.02
		PH      05.06.14
		PH      05.03.08
TION		BY      DATE
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
NG NO. 04		REV. C SHEET 1 OF 2
V LUG		SCALE NTS
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RELEASED  
08/12/18 MW

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.			AJS	08.12.02
B	UPDATE M-SPEC			PH	05.06.14
A	NEW ISSUE			PH	05.03.08
REV.	DESCRIPTION			BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS				
CHECKED		DRAWING NO.	REV. C		
MFG. APPR.		D3404	SHEET 1 OF 2		
APPROVED		TITLE	SCALE		
DE APPR.		GHW LUG	NTS		
DATE	08.12.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

## NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.34 lbs

8 7 6 5 4 3 2 1 0

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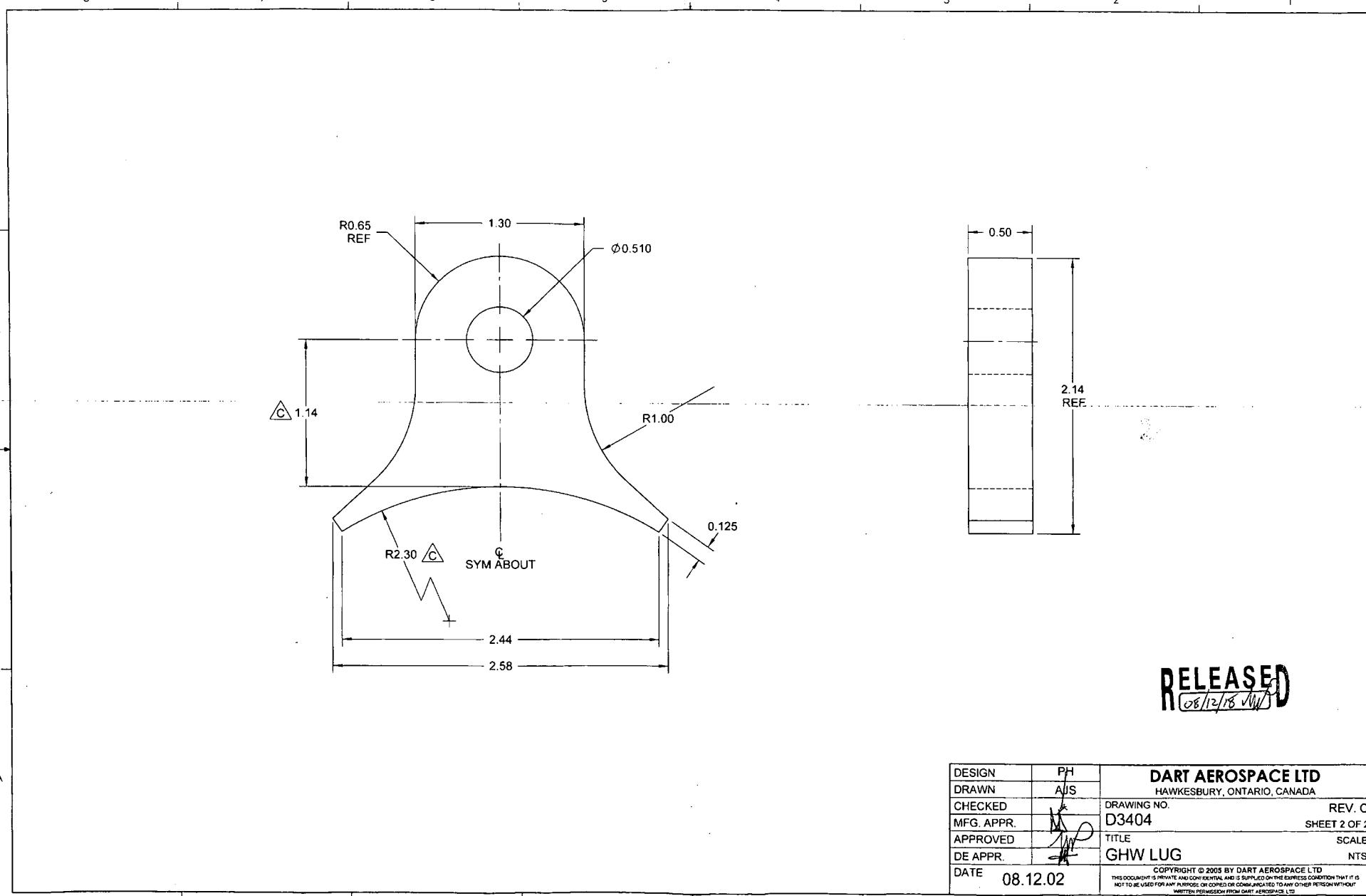
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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